

Date: Monday, 9/10/2007 1:27:49 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number	: 34486		
Estimate Number	: 12924		
P.O. Number	: <i>N/A</i>	Part Number	: D29321UP
This Issue	: 9/10/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2932 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: _____	Due Date	: 9/30/2007
Checked & Approved By	: <i>[Signature]</i> 07.09.11	Qty:	8 Um. Each
Comment	: Est Rev:A New Issue 07-07-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock:

7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length

Batch No: *33406*

spc'd 3460

BC 02.09.18

(8)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr & TUMBLE

BC /

S.F 02/09/19

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

BC /

S.F 02/09/19

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

BC /

S.F 02/09/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 07/09/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:27:49 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 34486

Part Number: D29321UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JD 07/09/20

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 07-09-20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/9/21 (9)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

st474 07/9/21 (9)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/21

Job Completion



U 07-09-21

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34486
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.117	.125	.125	.125		
C	0.100	0.140		.120	.126	.125	.125		
D	0.210	0.230		.219	.222	.222	.226		
E	1.245	1.255		1.250	1.250	1.245	1.245		
F	1.245	1.255		1.250	1.250	1.249	1.245		
G	2.495	2.505		2.500	2.501	2.499	2.499		
H	0.510	0.515		.510	.515	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.259	.257	.257	.257		
L	0.312	0.317		.313	.314	.314	.314		
M	0.235	0.240		.238	.238	.239	.239		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.552	.550	.550	.550		
P	0.490	0.510		.505	.504	.501	.501		
Q	3.715	3.725		3.720	3.718	3.718	3.718		
R	2.470	2.510		2.500	2.497	2.497	2.497		
S	0.240	0.270		.252	.256	.250	.256		
T	0.100	0.180		.140	.140	.138	.143		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.368	1.368	1.368		
W	0.316	0.321		.319	.319	.319	.319		
X	1.125	1.145		1.136	1.132	1.132	1.132		
Y	1.565	1.585		1.570	1.567	1.567	1.567		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	BC / Q.F.
Date:	07.09.18 / 07/09/19

Audited by:	SL
Date:	07/09/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	34486
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim.	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		.125	.124	.125	.125		
B	0.100	0.140		.125	.124	.125	.125		
C	0.100	0.140		.125	.125	.125	.125		
D	0.210	0.230		.228	.228	.228	.228		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262		.257	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.125	.125	.125	.125		
O	0.540	0.560		.550	.550	.550	.550		
P	0.490	0.510		.500	.500	.500	.500		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.501	2.501	2.501	2.501		
S	0.240	0.270		.250	.261	.260	.260		
T	0.100	0.180		.140	.147	.147	.147		
U	1.625	1.635		1.631	1.631	1.631	1.631		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.133	1.133	1.133	1.133		
Y	1.565	1.585		1.575	1.575	1.574	1.574		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.F.
Date:	07/09/19

Audited by:	J.L.
Date:	07/09/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

34486

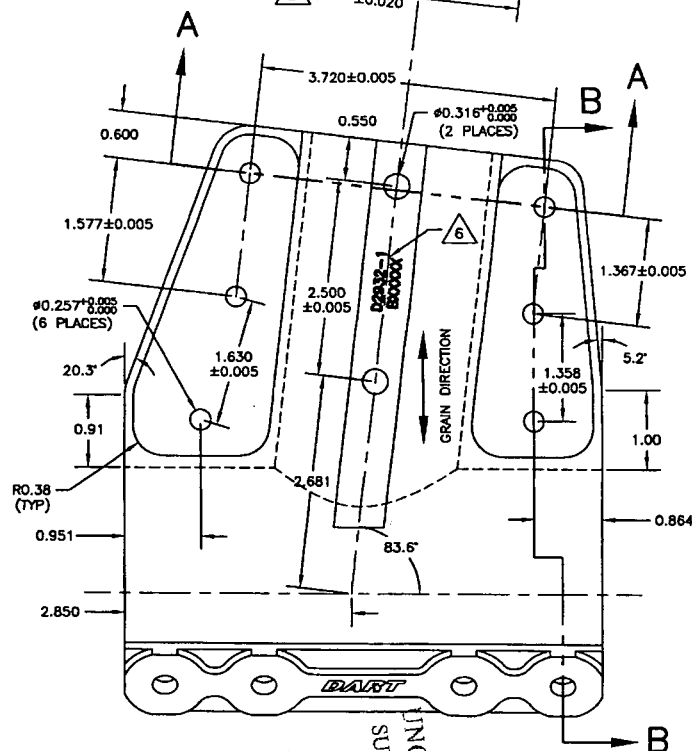
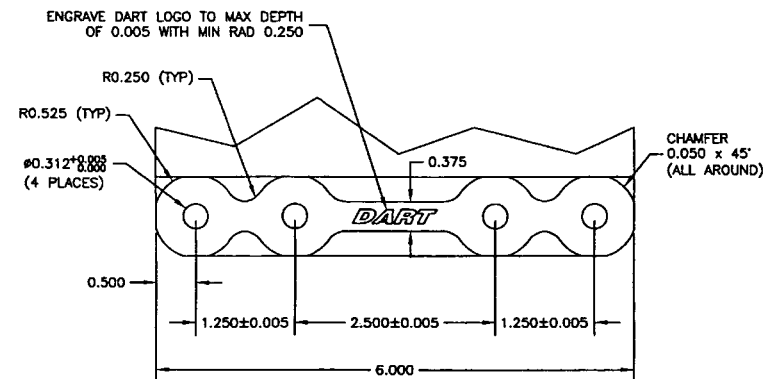
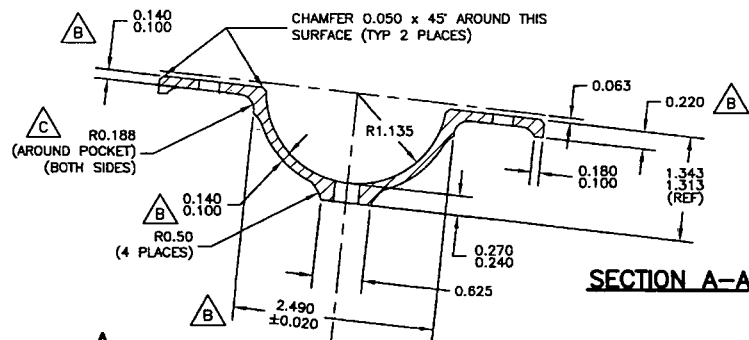
DART AEROSPACE LTD	Work Order: 34486
Description: 206 Saddle, Outboard, Left side	Part Number: D2932-1
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

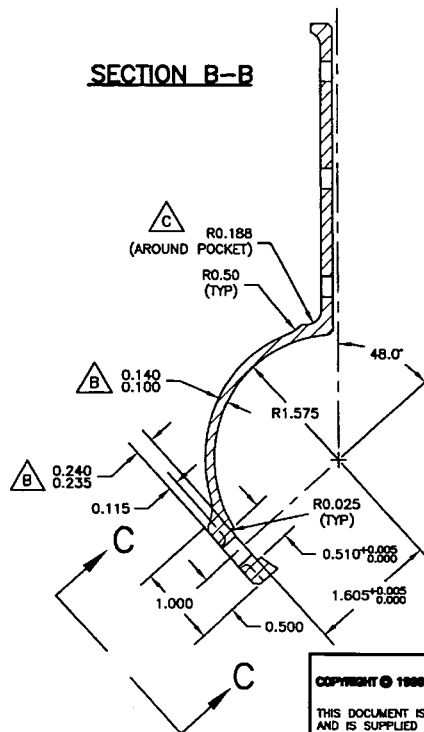
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.125					
B	0.100	0.140		.120					
C	0.100	0.140		.130					
D	0.210	0.230		.228					
E	1.245	1.255		1.250					
F	1.245	1.255		1.250					
G	2.495	2.505		2.500					
H	0.510	0.515		.510					
I	1.572	1.582		1.577					
J	2.495	2.505		2.500					
K	0.257	0.262		.258					
L	0.312	0.317		.313					
M	0.235	0.240		.238					
N	0.100	0.140		.125					
O	0.540	0.560		.550					
P	0.490	0.510		.507					
Q	3.715	3.725		3.720					
R	2.470	2.510		2.500					
S	0.240	0.270		.260					
T	0.100	0.180		.140					
U	1.625	1.635		1.630					
V	1.362	1.372		1.370					
W	0.316	0.321		.318					
X	1.125	1.145		1.132					
Y	1.565	1.585		1.568					
Z	0.178	0.198		.188					
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>S.P.</u> Date: <u>02/09/19</u>	Audited by: <u>J.L.</u> Date: <u>02/09/20</u>
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Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION B-B



D2932-1 LH SADDLE (SHOWN)
D2932-2 RH SADDLE (OPPOSITE)

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	BY AH	DRAWN BY CB
CHECKED	AH	APPROVED AH
DATE	06.11.09	
DRAWING NO.	D2932	REV. C
TITLE	SADDLE OUTSIDE	SHEET 1 OF 1
SCALE		2:3

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07-02-12

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